

## ABSTRACT

Disclosed herein is a method of controlling an assembly line, comprising the steps of providing an article assembly line; designating, on the assembly line, an upstream processing station and a downstream processing station;

5      delivering a first article to the upstream processing station; monitoring an upstream processing function on the first article within the upstream processing station; and if, the upstream processing function in the upstream processing station on a first article is not complete; issuing a signal to an operator in the upstream processing station that the upstream processing function on the first article is not complete; extending the length of the upstream processing station to allow the upstream operator more time to complete the upstream processing function; monitoring the

10     upstream processing function in the extended upstream processing station; and if the upstream processing function on the first article is still not complete; associating a label with the first article in the over travel processing station for downstream remedial attention; advancing the first article downstream from the extended upstream processing station; advancing a second article to the upstream processing station for the upstream processing function; and if the upstream processing function on the first article is complete; advancing the first article downstream from the

15     extended upstream processing station; advancing a second article to the upstream processing station for the upstream processing function.